



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**RBT400203-E**  
**Job Sheet 192003**



**Part No:** RBT400203-E

**Job Qty:** 6 pcs

DAG  
21  
9-89

**Part Name:** Spring



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 3/14/19

**Job Tracking No:**

**Due Date:** 3/28/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG RBT400203 Rev.5 IPP Rev. A 19.01.22 New issue DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation           | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|---------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                     |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 100   | Waterjet - Flow - 1 | 6 pcs | 3/28/19    | 3/28/19  | 0.00      | 1.20    | Waterjet - Flow       |           | dc 19/03/22 |
| 110   | QC 2                | 6 pcs | 3/28/19    | 3/28/19  | 0.00      | 0.00    | QC 2 - 1              |           |             |
|       |                     |       |            |          |           |         | QC 2 - 12             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 14             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 17             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 19             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 2              |           |             |
|       |                     |       |            |          |           |         | QC 2 - 20             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 22             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 23             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 25             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 32             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 33             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 35             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 39             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 4              |           |             |
|       |                     |       |            |          |           |         | QC 2 - 40             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 44             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 45             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 48             |           | dc 19/03/22 |
|       |                     |       |            |          |           |         | QC 2 - 49             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 50             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 51             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 52             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 54             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 56             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 57             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 62             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 63             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 8              |           |             |
|       |                     |       |            |          |           |         | QC 2 - 66             |           |             |

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|     |                                    |       |         |           |                        |  |
|-----|------------------------------------|-------|---------|-----------|------------------------|--|
| 120 | <b>QC 8</b>                        | 6 pcs | 3/28/19 | 0.00 0.00 | QC 2 - 64              |  |
|     |                                    |       |         |           | QC 2 - 65              |  |
|     |                                    |       |         |           | QC 8 - 12              |  |
|     |                                    |       |         |           | QC 8 - 14              |  |
|     |                                    |       |         |           | QC 8 - 17              |  |
|     |                                    |       |         |           | QC 8 - 20              |  |
|     |                                    |       |         |           | QC 8 - 25              |  |
|     |                                    |       |         |           | QC 8 - 3               |  |
|     |                                    |       |         |           | QC 8 - 32              |  |
|     |                                    |       |         |           | QC 8 - 33              |  |
|     |                                    |       |         |           | QC 8 - 35              |  |
|     |                                    |       |         |           | QC 8 - 39              |  |
|     |                                    |       |         |           | QC 8 - 4               |  |
|     |                                    |       |         |           | QC 8 - 44              |  |
|     |                                    |       |         |           | QC 8 - 45              |  |
|     |                                    |       |         |           | QC 8 - 49              |  |
|     |                                    |       |         |           | QC 8 - 58              |  |
|     |                                    |       |         |           | QC 8 - 8               |  |
|     |                                    |       |         |           | QC 8 - 9               |  |
|     |                                    |       |         |           | QC 8 - 68              |  |
|     |                                    |       |         |           | QC 8 - 67              |  |
|     |                                    |       |         |           | QC 8 - 1 (A)           |  |
|     |                                    |       |         |           | QC 8 - 47              |  |
|     |                                    |       |         |           | QC 8 - 40              |  |
| 130 | <b>Small Fab - 2 - B4B</b>         | 6 pcs | 3/28/19 | 0.00 1.50 | Small Fab - 1 - B4B    |  |
|     |                                    |       |         |           | Small Fab - 2 - B4B    |  |
|     |                                    |       |         |           | Small Fab - 3 - B4B    |  |
|     |                                    |       |         |           | Small Fab - 4 - B4B    |  |
|     |                                    |       |         |           | Small Fab - 5 - B4B    |  |
|     |                                    |       |         |           | Small Fab - 6 - B4B    |  |
|     |                                    |       |         |           | Small Fab - 7 - B4B    |  |
| 140 | <b>QC 5</b>                        | 6 pcs | 3/28/19 | 0.00 0.00 | QC 5 - 10              |  |
|     |                                    |       |         |           | QC 5 - 12              |  |
|     |                                    |       |         |           | QC 5 - 17              |  |
|     |                                    |       |         |           | QC 5 - 18              |  |
|     |                                    |       |         |           | QC 5 - 19              |  |
|     |                                    |       |         |           | QC 5 - 22              |  |
|     |                                    |       |         |           | QC 5 - 24              |  |
|     |                                    |       |         |           | QC 5 - 3               |  |
|     |                                    |       |         |           | QC 5 - 42              |  |
|     |                                    |       |         |           | QC 5 - 43              |  |
|     |                                    |       |         |           | QC 5 - 49              |  |
|     |                                    |       |         |           | QC 5 - 51              |  |
|     |                                    |       |         |           | QC 5 - 58              |  |
|     |                                    |       |         |           | QC 5 - 68              |  |
|     |                                    |       |         |           | QC 5 - 9               |  |
|     |                                    |       |         |           | QC 5 - 50              |  |
|     |                                    |       |         |           | QC 5 - 30              |  |
|     |                                    |       |         |           | QC 5 - 40              |  |
| 150 | <b>Packaging 3-1 - Stock - B4B</b> | 6 pcs | 3/28/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |  |
|     |                                    |       |         |           | Packaging 3 - 2 - B4B  |  |
|     |                                    |       |         |           | Packaging 3 - 3 - B4B  |  |
|     |                                    |       |         |           | Packaging 3 - 4 - B4B  |  |
|     |                                    |       |         |           | Packaging 3 - 5 - B4B  |  |
|     |                                    |       |         |           | Packaging 3 - 6 - B4B  |  |
|     |                                    |       |         |           | Packaging 3 - 7 - B4B  |  |
|     |                                    |       |         |           | Packaging 3 - 8 - B4B  |  |
|     |                                    |       |         |           | Packaging 3 - 9 - B4B  |  |
|     |                                    |       |         |           | Packaging 3 - 10 - B4B |  |

MAR 25 2019  
DAS 40  
9-89

MAR 30 2019  
DAS 30  
9-89

MAR 26 2019

MAR 26 2019  
DAS 40  
9-89

DAS 28  
9-89

|                                                                                                     |                              |                     |                         |           | Packaging 3 - 11 - B4B |             |
|-----------------------------------------------------------------------------------------------------|------------------------------|---------------------|-------------------------|-----------|------------------------|-------------|
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 12 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 13 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 14 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 15 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 16 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 17 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 18 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 19 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 20 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 21 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 22 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 23 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 24 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 25 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 26 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 27 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 28 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 29 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 30 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 31 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 32 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 33 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 34 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 35 - B4B |             |
|                                                                                                     |                              |                     |                         |           | Packaging 3 - 36 - B4B |             |
| 160                                                                                                 | QC 21 - SA                   | 6 pcs               | 3/28/19                 | 0.00 0.00 | QC 21 - SA - 21        | DAG         |
|                                                                                                     |                              |                     |                         |           | QC 21 - SA - 70        | 21          |
|                                                                                                     |                              |                     |                         |           | QC 21 - SA - 53        | 3-53        |
| Part Op <b>100</b> - 1-Cut as per DWG. DWG. Rev: <u>5</u> PROG. Rev: <u>5</u> 2-Deburr if necessary |                              |                     |                         |           |                        | MAR 27 2019 |
| Descriptions: <b>130</b> - Form as per DWG.                                                         |                              |                     |                         |           |                        |             |
| <b>Job BOM</b>                                                                                      |                              |                     |                         |           |                        |             |
| Part / Item                                                                                         | Component Name               | Quantity            | Operation               | Container |                        |             |
| M301S19GA                                                                                           | 301 SS Sheet 1/2 Hard (.040) | .2664 sf (.0444 ea) | 100-Waterjet - Flow - 1 |           | 5087764                |             |
|                                                                                                     |                              |                     |                         |           |                        |             |
| <b>Job Allocations</b>                                                                              |                              |                     |                         |           |                        |             |
| Operation                                                                                           | Component Part               | Required            | Inventory               | Allocated |                        |             |
| 100-Waterjet - Flow - 1                                                                             | M301S19GA                    | 0                   | 52                      | 0         |                        |             |
|                                                                                                     |                              |                     |                         |           |                        |             |
| <b>Part Specifications</b>                                                                          |                              |                     |                         |           |                        |             |
|                                                                                                     |                              |                     |                         |           |                        |             |
| Specifications could not be found.                                                                  |                              |                     |                         |           |                        |             |

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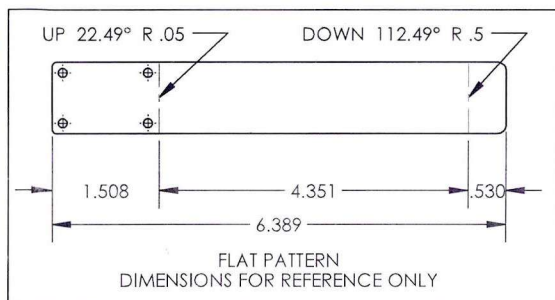
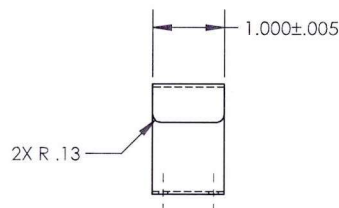
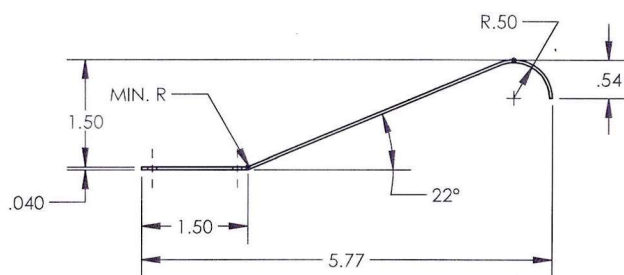
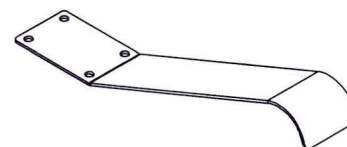
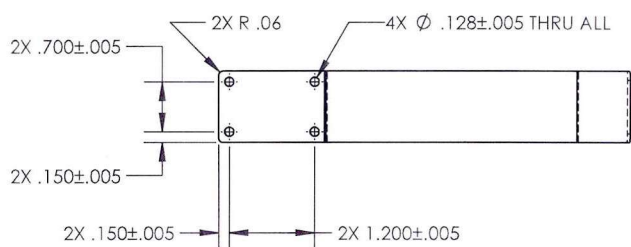


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WORK ORDER

NO 191816 M15  
192003 19-03-11

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| REVISIONS |         |                                                                                    |           |         |          |
|-----------|---------|------------------------------------------------------------------------------------|-----------|---------|----------|
| REV       | ECR     | DESCRIPTION                                                                        | DATE      | INITIAL | APPROVED |
| 2         |         | ADDED OUTSIDE RADIUS TO -E.                                                        | 1/9/2008  | WP      | RW       |
| 3         |         | REMOVED -E FLAT LAYOUT AND SUPPLIED MISSING OVER ALL DIMENSION.                    | 4/20/2009 | WP      | RW       |
| 4         |         | ADDED +/- .030 LIMITS TO DIMS (1.50, 5.76, .54, R.5), ADDED MISSING ANGLE DIM 22°. | 2/13/2013 | BIM     | SE       |
| 5         | 16-0027 | -E CHD TO SHEET METAL TOLERANCES. DELETED SAME SPRING CLIP USED ON T101456 NOTE.   | 2/9/2016  | DPD     | SM       |



(-E)

SPRING CLIP

|                                 |                              |
|---------------------------------|------------------------------|
| <b>DART<br/>AEROSPACE</b>       |                              |
| TITLE<br>TRIM TAB BENDING GAUGE |                              |
| DWG NO.<br>RBT400203-E          | REV<br>5                     |
| MAT'L 301 S.S.                  | UNLESS OTHERWISE SPECIFIED   |
| HEAT TREAT                      | DIMENSIONS ARE IN INCHES     |
| FINISH                          | .XXX ± .010 FRACTIONS ± 1/8  |
| SPEC                            | .XX ± .03 ANGLES ± 1°        |
|                                 | .X ± .1 SURFACES ± 125/      |
| DRAWN BY: COLE                  | 1. BREAK ALL SHARP EDGES     |
| CHECKED: CLOUGH                 | .015 x 45° OR .015R          |
| OPPS APPR: ANDERSON             | 2. DIMENSIONAL LIMITS APPLY  |
| QA APPR: LINDSAY                | AFTER PLATING                |
| APPROVED: MACKOVJAK             | 3. INTERPRET DIM AND TOL PER |
|                                 | ASME Y14.6M-2009             |
|                                 | USED ON MODEL                |
|                                 | BELL 206                     |
| SCALE 1:2                       | DATE 1/10/2002               |
|                                 | SHEET 7 OF 11                |

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Sequence #: _____                                                                                                                 | QTY Affected : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 832-6200  
Email: sales@dartaero.com  
www.dartaerospace.com

Container No: S165378



Part: RBT400203-E

Job No: 192003

Serial No/Batch: S165378

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 03/22/19